

Work Order ID 61512

Monday, August 30, 2010 9:16:16 AM



Page 1

Item ID: D3822-7KIV

Accept



Setup Start



Revision ID:

Item Name: Vertical Tunnel, Lower-Ivory

Stop



Start Date: 8/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-8-30 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3822	lw c

100



HandThermo

Hand Finishing Thermoforming

Memo

0.00

x1

Dh

10/11/04

105



Dry Material

0.00

Mh

10/11/04

HandThermo

Hand Finishing Thermoforming

Memo

0.00

Dry Sheet as per QSI022 KYDEX

Temp: 140°F

Time IN: 4:20 pm 10/11/03

Time OUT: 7:00 am 10/11/04

W/O: 61512

PERM CHG

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/11/08	#100	Update lead box to have correct information	SLH	10/11/08			S 10/11/08

Part No: D3822-7K1V PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110



Thermoform

Thermoforming Machine

Memo

0.00

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA029 using tool DT9396
Dwg Rev: C
Folio Rev: B.

 10/11/04

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Visually inspect part for proper formation and texture

 10/11/04

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

 10/11/04

W/O:		WORK ORDER CHANGES					
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Page 3

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Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



HandThermo

Hand Finishing Thermoforming

Memo

1-Trim to finished dimensions as per Dwg

0.00

(X)

Wk

10/4/24

150



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

Complete FAI document

0.00

(X)

Wk

10/4/24

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

10/4/24

(X)

Wk

10/4/24

W/O:		WORK ORDER CHANGES					
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Stop



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Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

170



Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location: 152Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

180

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MF

10-11-9

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Monday, August 30, 2010 9:16:20 AM

Page 1

Work Order ID: 61512



Parent Item: D3822-7KIV



Parent Item Name: Vertical Tunnel, Lower-Ivory

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

Ipp Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	588.8500	1.76	1.760880			

6185 KYDEX .080"



Location	Loc Qty	Loc Code
therm	588.85	
(109703)	588.85	

2.16 sq ft. Dr.
10/4/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	G1512
Description: Vertical Tunnel, Lower	Part Number:	D3822-7KIV/KGY
Inspection Dwg: D3822 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: *W.H.* Date: *10/11/04*

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.20 - 0.15	Min	0.25"	✓			
0.060	Min	0.060	✓			
2.0 "	MIN. 1.11 "	1.06	✓			
17.0 "	MIN.	17.25	✓			
0.4 "	MIN.	.5"	✓			
0.2 "	MIN.	0.25"	✓			
5.9	± 100	582	✓			

Measured by: *JL.* Date: *10/11/04*

Audited by: *DR.* Date: *10/11/04*

Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	M

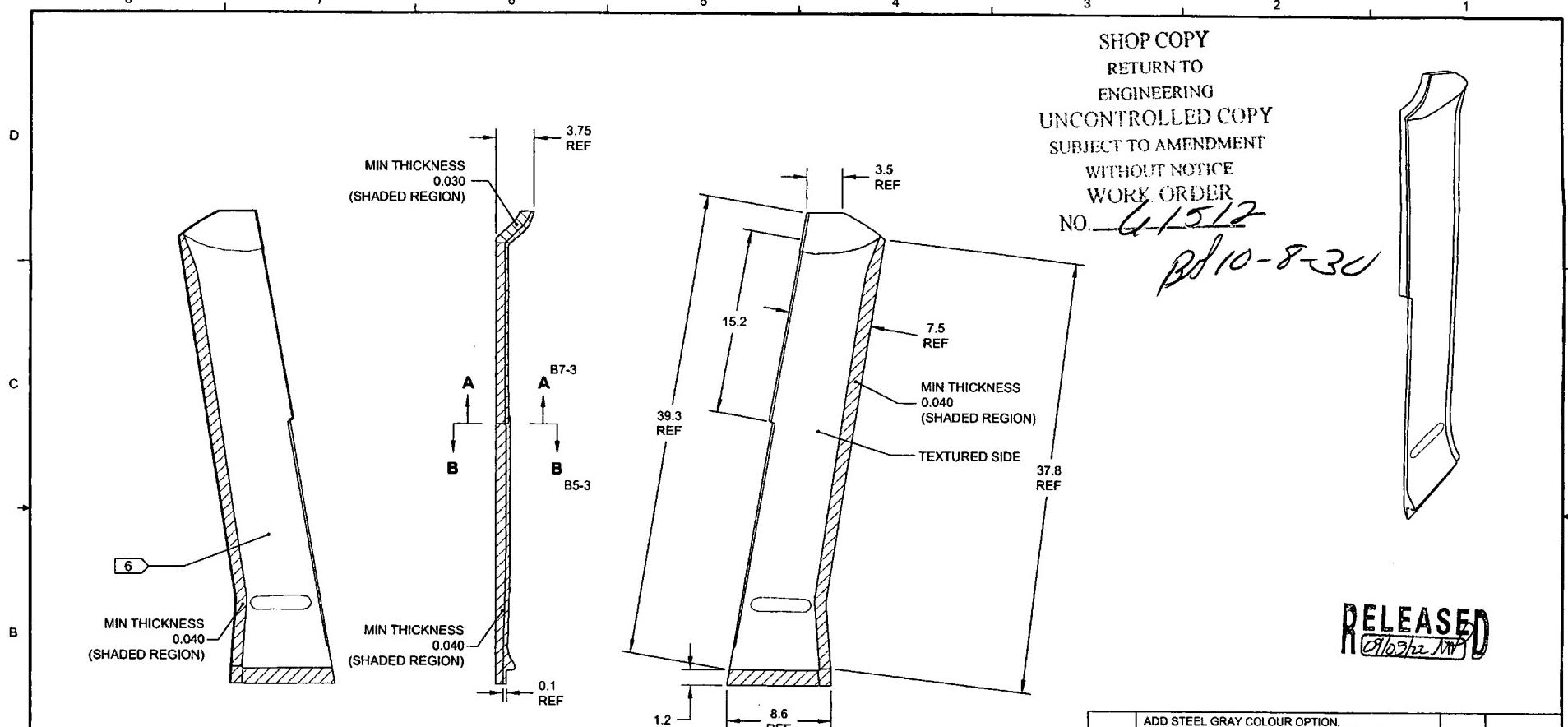
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3822-1 VERTICAL TUNNEL, LH
(BELL 206 A/B)

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9073 PER DART QSI 022. TRIM PER MOLD.
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

C
C

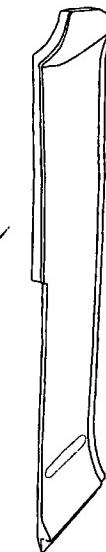
PART NUMBER	DESCRIPTION
D3822-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. G1512

Bd10-8-30



RELEASED
01/03/12 MTP

C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N'S D3822-1-2/3-5/-7(KIV) AND ADD STEEL GRAY P/N'S D3822-1-2/3-5/-7(KGY) (ZN A5-1, A5-2, A5-4, A5-5, A5-6)	PH	09.05.05
B	37.8 WAS 38.8 (ZN C8-4); MODIFY TOP OF -3 AND ADD VIEW J (ZN A3-4); INCREASE JOGGLE ON -3 (ZN C6-4); UPDATE VIEW F (ZN A1-4); REASON: TO IMPROVE FIT OF D206-781-151 KIT	PH	09.02.09
A	NEW ISSUE	PH	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RJ	DART AEROSPACE LTD	
DRAWN	RJ	HAWKSLEY, ONTARIO, CANADA	
CHECKED	RJ	REV. C	
MFG. APPR.	RJ	DRAWING NO.	
APPROVED	RJ	D3822	SHEET 1 OF 6
DE APPR.	RJ	TITLE	SCALE
DATE	09.05.05	VERTICAL TUNNEL (BELL 206 A/B)	NTS

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8 7 6 5 4 3 2 1

D

C

B

A

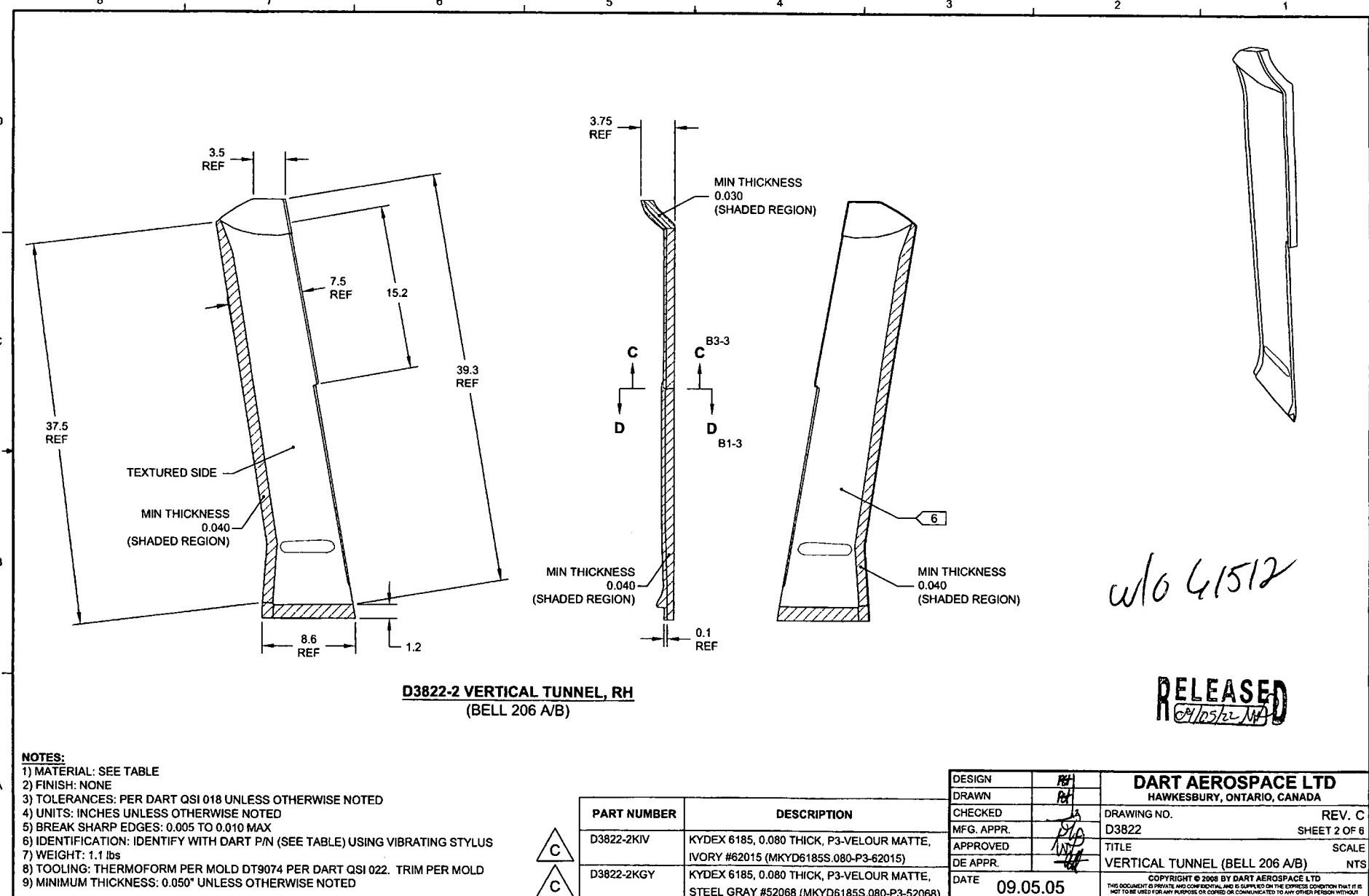
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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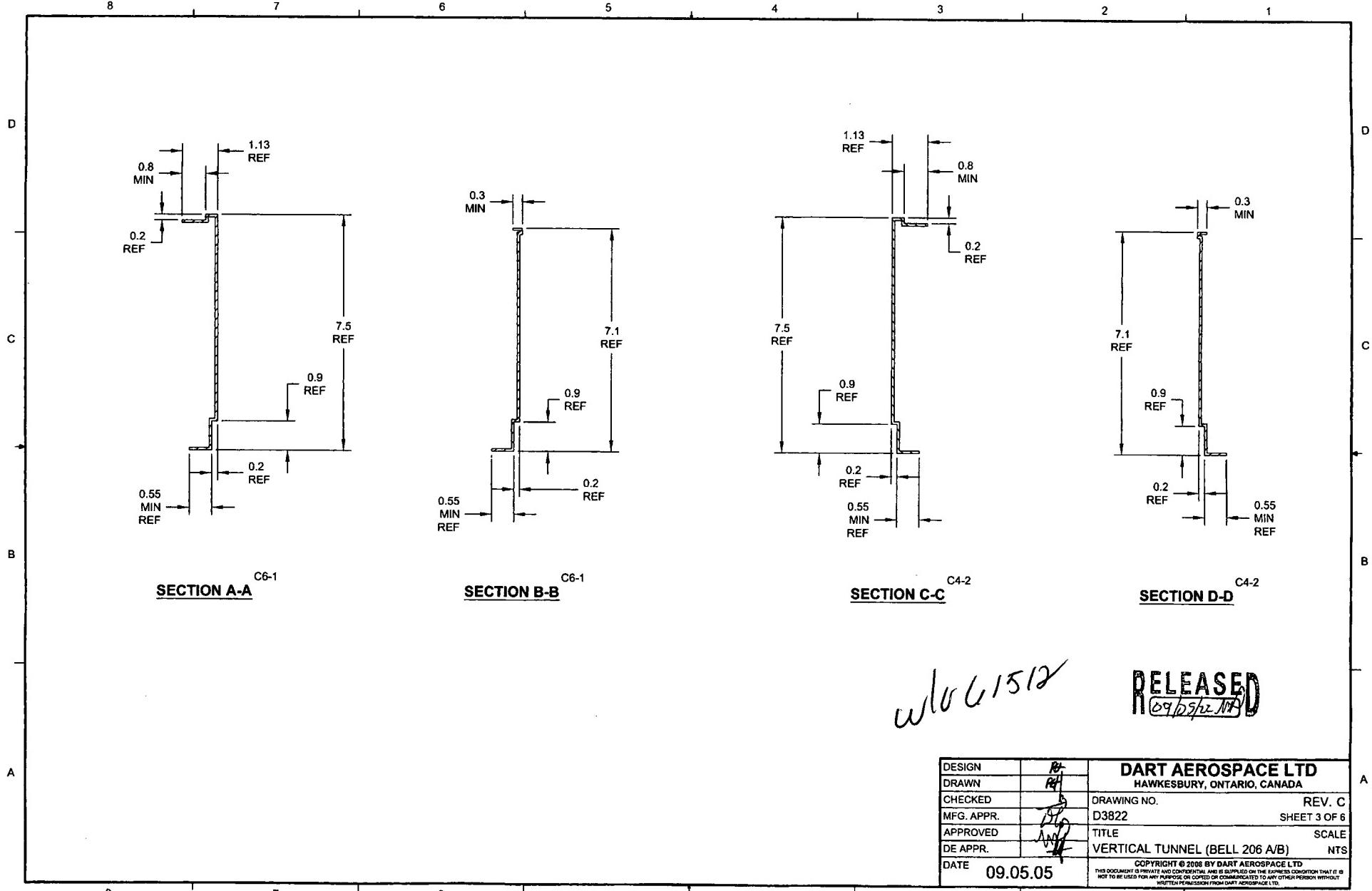
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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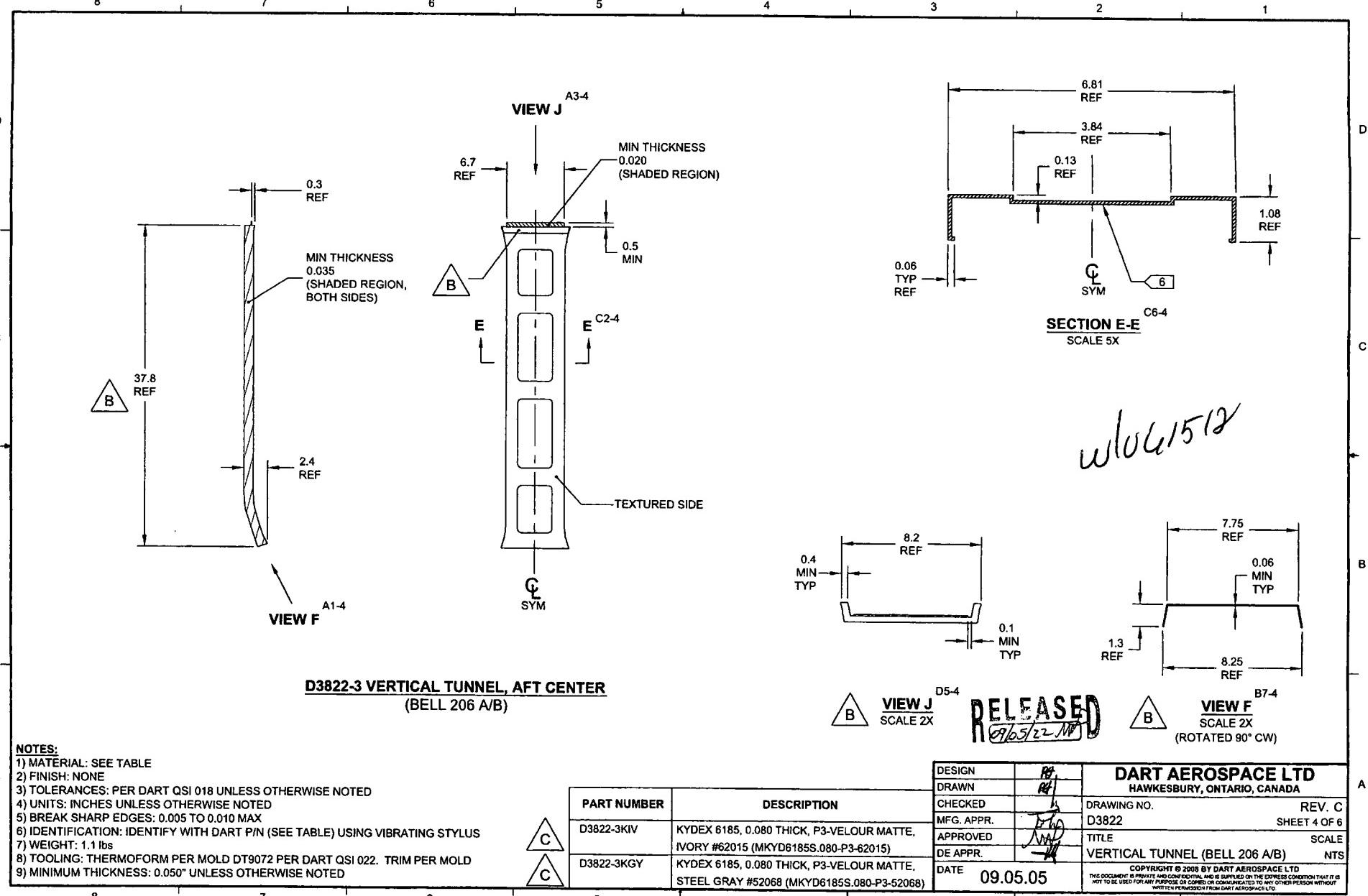
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DRAWN	R	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3822 SHEET 3 OF 6
APPROVED		TITLE SCALE
DE APPR.		VERTICAL TUNNEL (BELL 206 A/B) NTS
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W/O:		WORK ORDER CHANGES					
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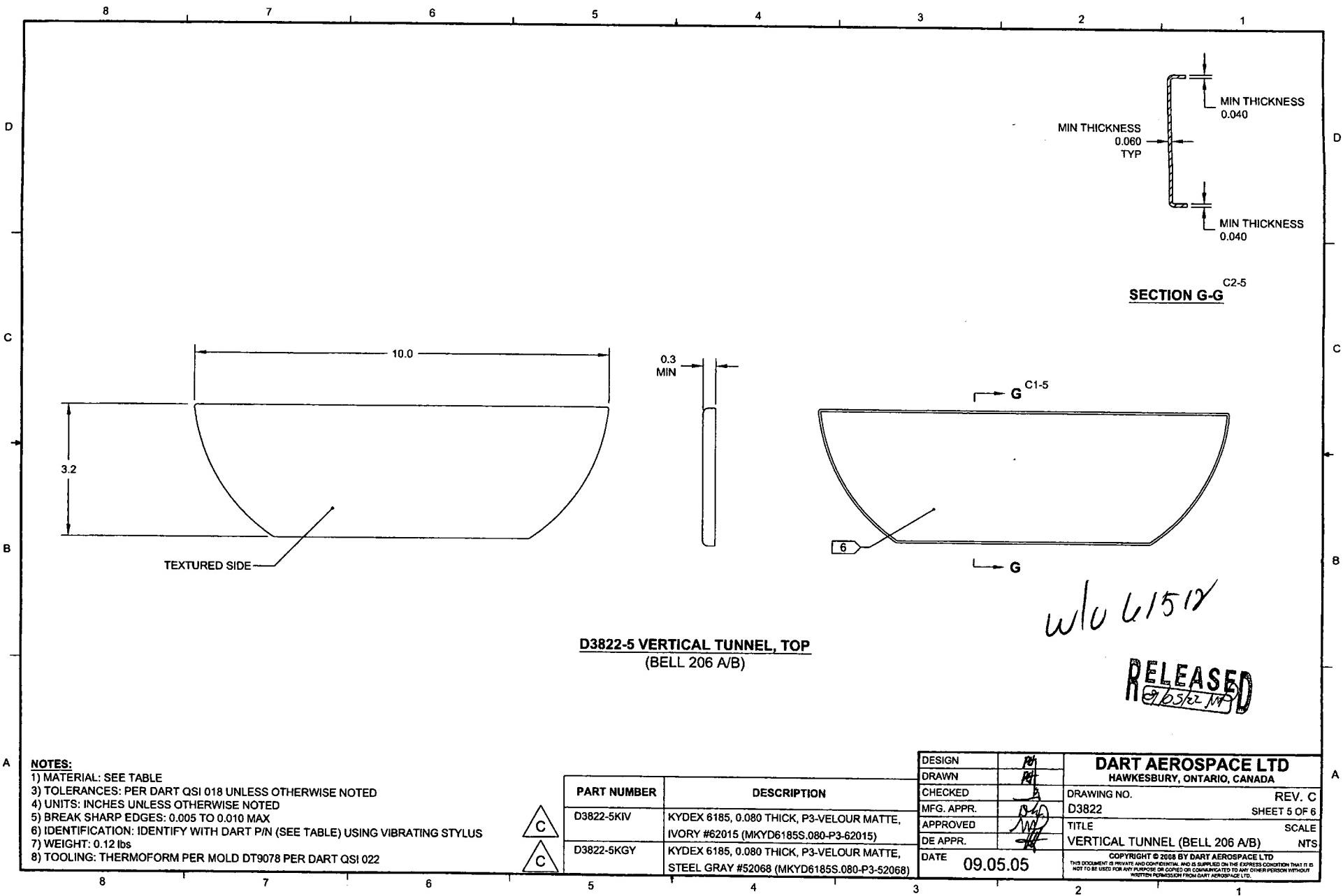
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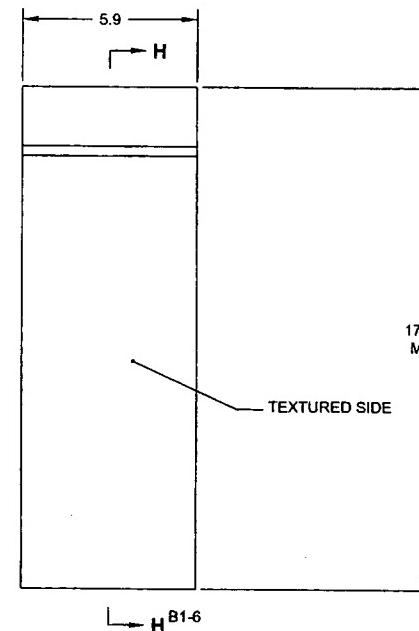
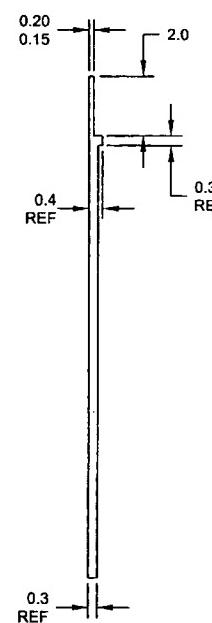
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8 7 6 5 4 3 2 1

D

MIN THICKNESS
0.040MIN THICKNESS
0.040WUW1512
SECTION H-H**RELEASED**
09/05/22 MTA

D3822-7 VERTICAL TUNNEL, LOWER
(BELL 206 A/B)

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) WITH VIBRATING STYLUS
- 7) WEIGHT: 0.36 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9396 PER DART QSI 022
- 9) MINIMUM THICKNESS: 0.060" UNLESS OTHERWISE NOTED



PART NUMBER	DESCRIPTION
D3822-7KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-7KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	<i>PA</i>	DART AEROSPACE LTD
DRAWN	<i>PA</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>A</i>	
MFG. APPR.	<i>PA</i>	
APPROVED	<i>PA</i>	
DE APPR.	<i>PA</i>	
DATE	09.05.05	REV. C
		SHEET 6 OF 6
DRAWING NO.	D3822	TITLE
		SCALE
		VERTICAL TUNNEL (BELL 206 A/B) NTS
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8 7 6 5 4 3 2 1

D

C

C

B

A

W/O:		WORK ORDER CHANGES					
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